

**Work Order ID 71628**

Page 1

Thursday, July 07, 2011 11:21:25 AM

Item ID: D3259-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: YMFDate: 11-07-07 Tooling:

Date:

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3259	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

2024 .063I-Cut as per Dwg D3259  Dwg Rev: B  Prog Rev: B  2-  
Deburr if necessaryB11-8-12

(4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S Wloski(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



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Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**

## Tool ID

## Tool #

**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

4X Øm-fu/08/29

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Wk305P

Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location ST1809

0.00

SP

SP 11-08-30

Memo

0.00

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Doubler

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Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release



QC

Quality Control

0.00

Memo

0.00

u/8/30/08  
MF  
11-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

# Picklist Print

Thursday, July 07, 2011 11:21:23 AM

Page 1

Work Order ID: 71628



Parent Item: D3259-3



Parent Item Name: Doubler

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC  
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	250.3800	1.388	5.844211			

2024-T3 .063 sheet



Location	Loc Qty	Loc Code
MAT022	250.38	
117018	25.88	
117392	224.5	117392

B11-8-12

(4)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71628
Description: Doubler	Part Number:	D3259-3/-4
Inspection Dwg: D3259 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	8.999	L		P/R w/SGZ	
1.000	+/-0.005	1.000	>		V IBGZ	
0.260	+/-0.010	.258	X		V	
R0.25	+/-0.030	.25	<		R.G	
R0.50	+/-0.030	.50	>		R.G	
5.000	+/-0.005	4.996	>		V	
0.875	+/-0.005	.873	X		V	
12.000	+/-0.005	11.994	>		P	
3.500	+/-0.005	3.498	L		V	
0.875	+/-0.005	.876	L		V	
R0.13	+/-0.030	.13	>		R.G	
0.500	+/-0.005	.499	>		V	
0.525	+/-0.005	.524	>		V	
1.80	+/-0.030	1.864	>		V	
Ø0.128	+0.005/-0.000	.129	>		V	
Ø0.377	+0.005/-0.000	.377	>		V	
Ø0.098	+0.005/-0.000	.102	>		V	
0.063 thick	+/-0.005	.063	X		V	
Grain Direction	N/A		>			

Measured by:	RB	Audited by:	S	Preliminary Approval:	
Date:	11-8-12	Date:	11/08/12	Date:	

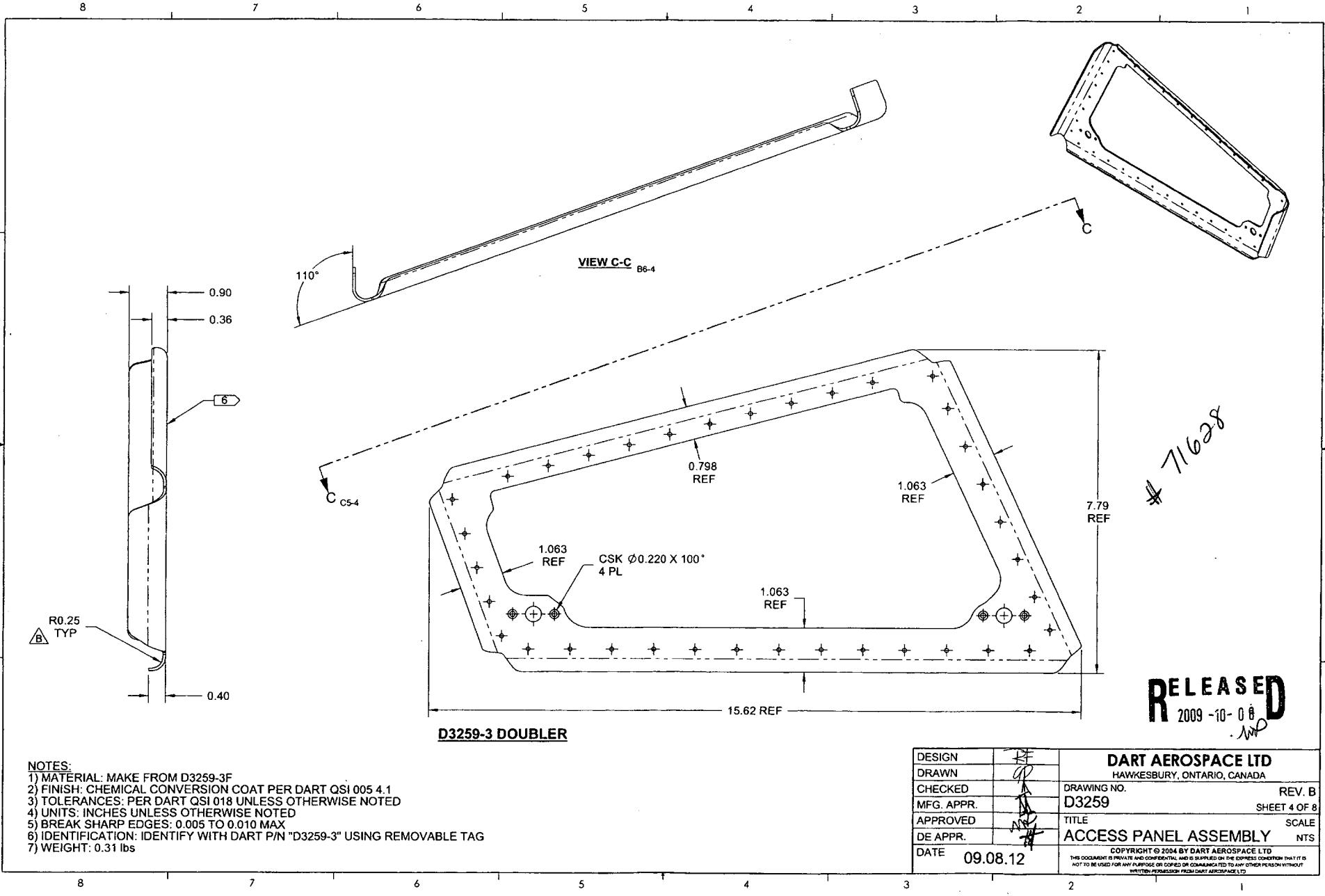
Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	
C	10.08.03	Dimensions updated	KJ	JL

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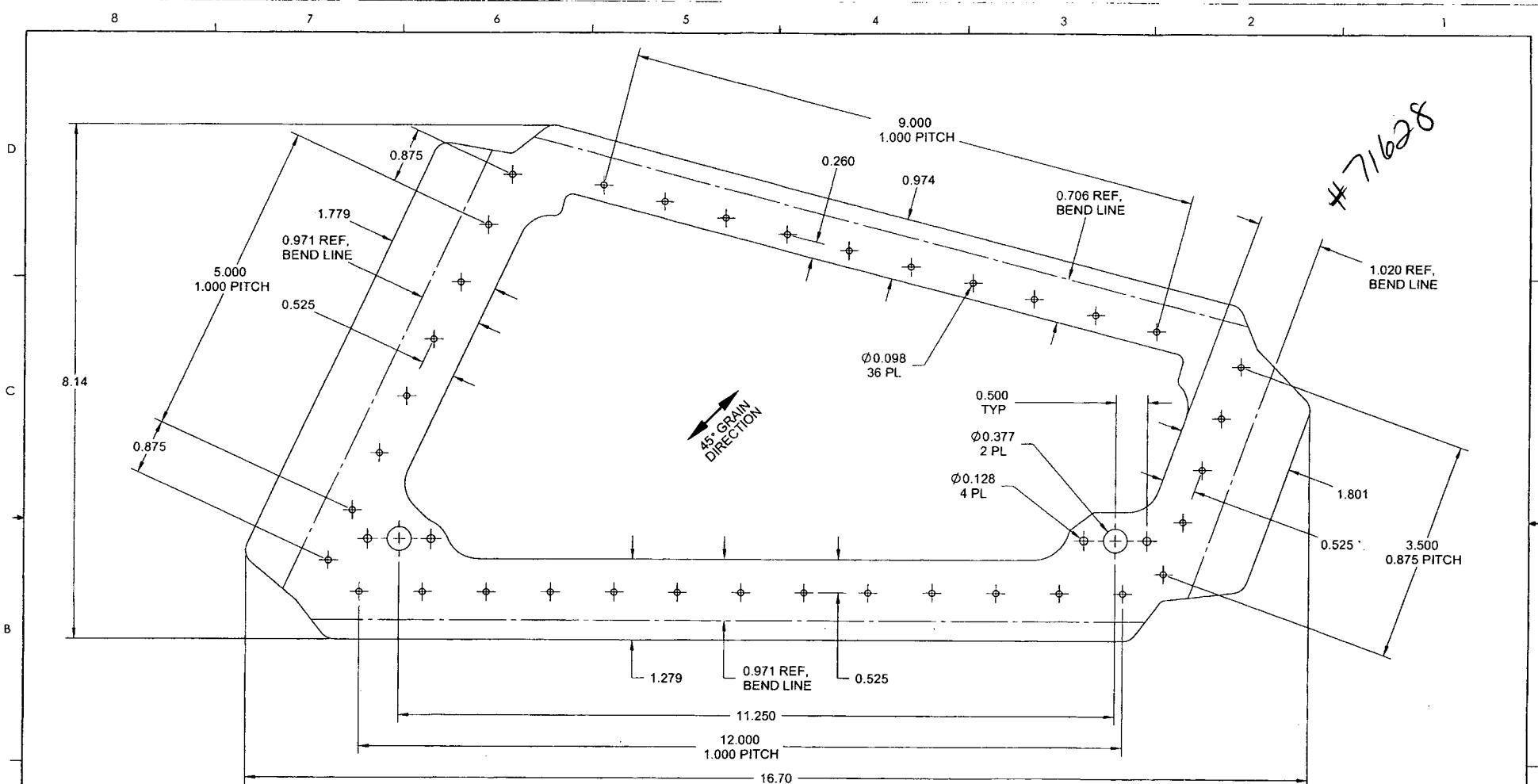


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D3259-3F DOUBLER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

**RELEASED**  
2009-10-08

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3259
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 6 OF 8
DE APPR.	<i>[Signature]</i>	TITLE ACCESS PANEL ASSEMBLY
DATE 09.08.12		SCALE NTS

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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